

Work Order ID 72508 -1

Wednesday, July 27, 2011 11:47:39 AM

Page 1

Item ID: D3564-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 7/27/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals: Process Plan:

Date: 11/07/27 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3564

Rev D

100

0.00



FLOW WATER JET

Memo

0.00

Waterjet

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog
Rev: D 2-Deburr if necessary

11/07/28

12

110

0.00



QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

QC

Quality Control

11/07/28

12

120

0.00



QC8- Inspect parts - second check

Memo

0.00

QC

Quality Control

8/10/29

712

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wednesday, July 27, 2011 11:47:39 AM



Accept



Setup Start



Stop



Cust Item ID:



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Insp.
Stamp

0.00



Brake NC

NC BRAKE

Memo

0.00

Deburr if necessary. Form on Brake as per Dwg D3564 using Jigs DT 8179 and DT 8155. Form Joggles (2) as per Dwg D3564 on brake using Jig DT 8157

SB 11/08/02 (12)

0.00



OC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Ensure joggle as per dwg D3429

$$\delta u / \log |s|$$

(42)

0.00



Large Fab

Large Fab

Memo

0.00

Qty	Description	Batch	A/R	2059B Hardcoat
M 118453	Weld hardcoat as per Dwg D3437			

Q 11-8-3 (x2)

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D3564-1

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Item Name: Wearshoe

Start Date: 7/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Sulosloz

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulosloz

(x2)

Quality Control

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

START TIME: *11:00pm* OVEN TEMPERATURE:
FINISH TIME: *3:20*

Powder Coating

x2 *φ* *Mulosloz*

W/O:		WORK ORDER CHANGES					
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Page 4

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Start Date: 7/27/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 8/2/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/8/3 2 12

200

Identify as per dwg & Stock Location: FP-L7

0.00



Packaging

Memo

0.00

Packaging

2 2 11/08/03

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/08/03

11-08-3
2

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NOTE: Date & initial all entries

Picklist Print

Wednesday, July 27, 2011 11:47:46 AM

Page 1

Work Order ID: 72508

Parent Item: D3564-I

Parent Item Name: Wearshoe



Start Date: 7/27/2011

Required Date: 8/2/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	212.0000	1.41	17.81053			

304/316 Sheet .063

Location	Loc Qty	Loc Code
MAT020	19.4	
117275	1.7	
117653	17.7	
MAT021	192.6	
118217	192.6	

18 11/01/28

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	72508
Description: Wearshoe		Part Number:	D3564-1
Inspection Dwg: D3564	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.227	+/-0.010	3.232	—		RA26	Jam
2.432	+/-0.010	2.440	—		"	
2.50	+/-0.030	2.503	—		"	
6.000	+/-0.010	6.005	—		"	
12.104	+/-0.010	12.104	—		RA04	Tape
18.000	+/-0.010	18.000	—		"	
18.00	+/-0.030	18.00	—		"	
9.00	+/-0.030	9.00	—		"	
11.50	+/-0.030	11.50	—		"	
0.300 x 0.300	+/-0.010	.296x.296	—		RA26	Jam
Ø0.188	+0.005/-0.001	.187	—		RA26	
R0.375	+/-0.010	R.375	—		RA04	Tape Rad gauge
0.063	+/-0.010	.058	—		RA26	Jam

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 11/07/28	Date: 11/09/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.06	New Issue	KJ/JLM	
B	09.05.07	Dwg Rev updated	KJ/EC	

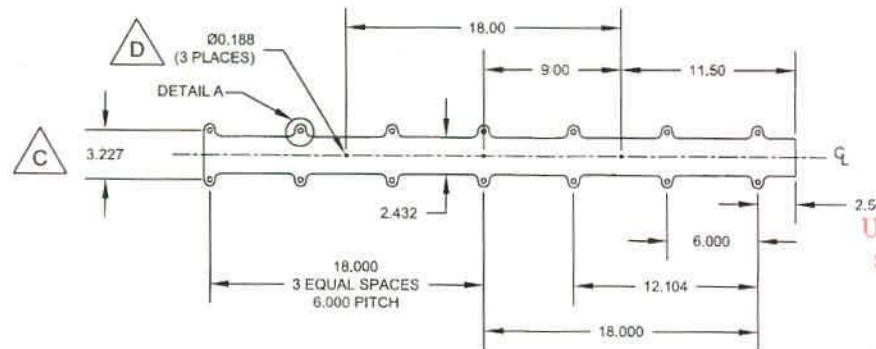
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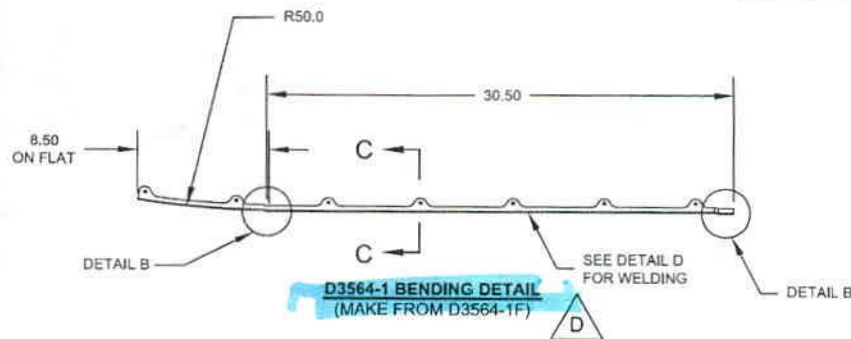
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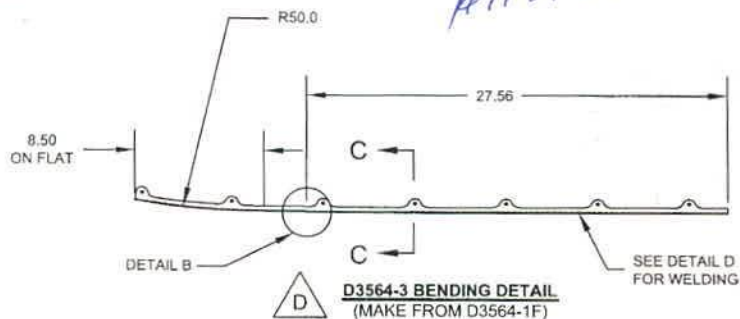
D3564-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72508
PR 11 07-27

RELEASED
07.09.04



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7, A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2016 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

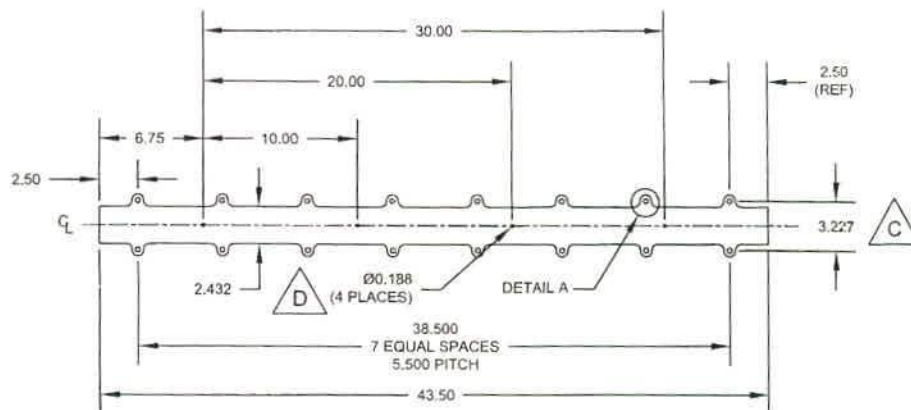
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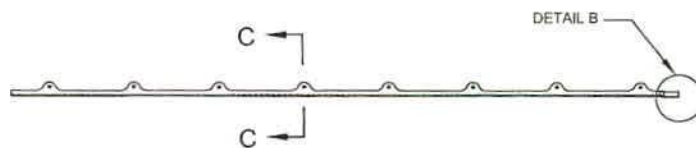
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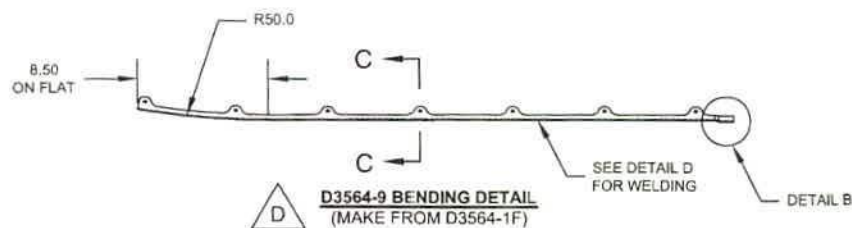
NOTE: Date & initial all entries



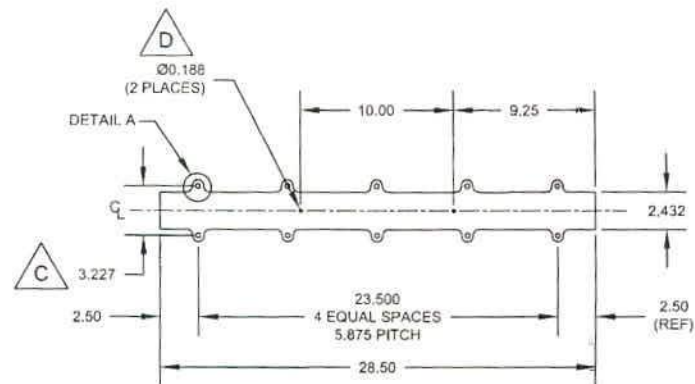
D3564-5F FLAT PATTERN



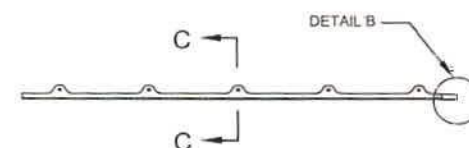
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



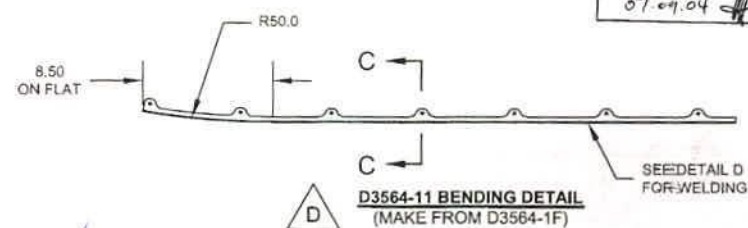
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

72508

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CB		
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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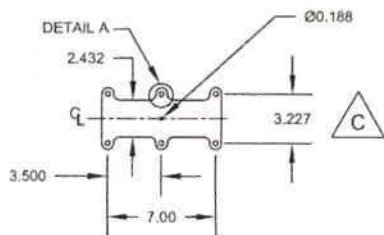
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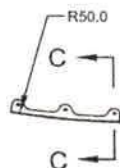
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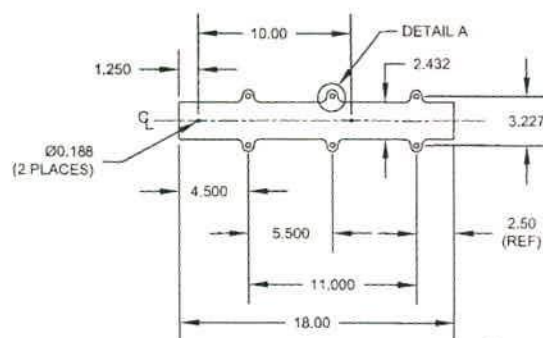
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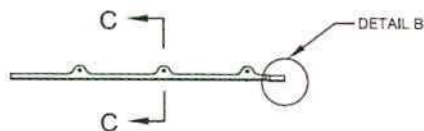
D3564-13F FLAT PATTERN



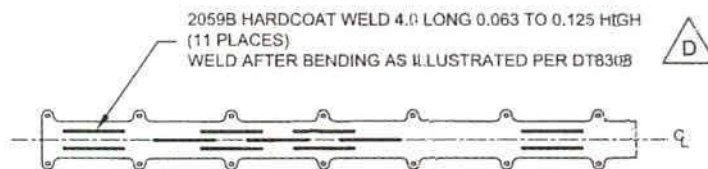
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



D3564-15F FLAT PATTERN



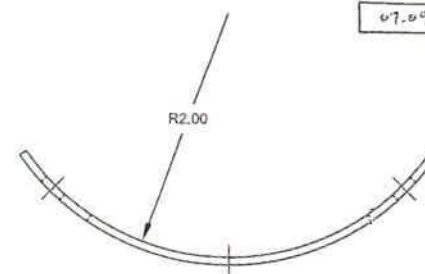
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



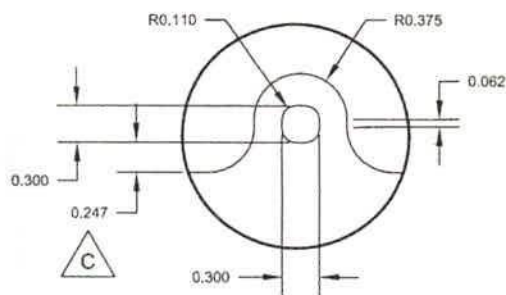
DETAIL D
(D3564-1/3/-9/-11 WELDING DETAIL)

RELEASED

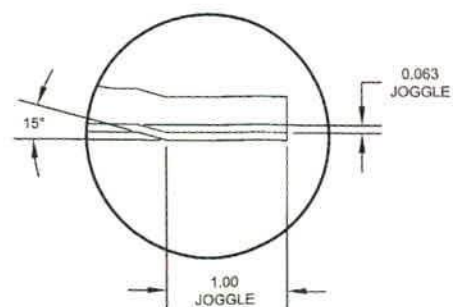
07.07.04



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 3 OF 3
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